

Work Order ID 113214

February-12-14 8:59:29 AM

113214

Page 1

Item ID: D4132-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gasket
Start Date: 2/10/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 2/10/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: MP Date: 14-02-14 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4132	B								

100	FLOW WATER JET	0.00						DAS 46 9-89	
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100
Waterjet
FLOW CNC Waterjet
neo .063"
Memo
1-Cut as per Dwg D4132
Dwg Rev: B
Prog Rev: B
2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00						DAS 46 9-89	
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110
QC
Quality Control
Memo

120	QC8- Inspect parts - second check	0.00						DAS 38 9-89	
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120
QC
Quality Control
Memo

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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February-12-14 8:59:29 AM

Page 2

Quality Control

MLJ 14-08-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data									
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Unapproved									

FAULT CATEGORY

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Picklist Print

February-12-14 8:59:34 AM

Page 1

Work Order ID: 113214

113214

Parent Item: D4132-3

D4132-3

Parent Item Name: Gasket

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
10.11.22 AS PER DWG REV.B DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	27.1000	1.0446	3	DAS 46 9-89		
MNEO60S 063													
NEOPRENE SHEET 0.063													

DC 14/08/19

Location

Loc Qty

Loc Code

MAT052

27.1

M126546

27.1

M128266

6.0

DQA: _____ Date: _____



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FAULT CATEGORY

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DART AEROSPACE LTD		Work Order: 113214
Description:		Part Number: 09132-3
Inspection Dwg: 104132 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

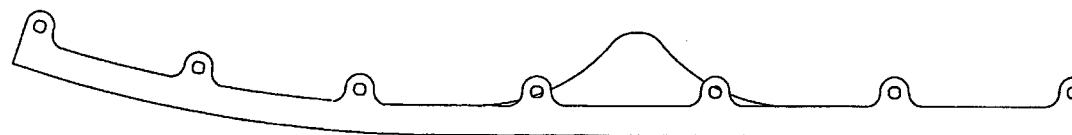
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.31	-0.001 +0.008	0.31	/		V	JKM-01
0.49	-0.001 +0.005	0.49	/		V	" "
.34	+/- 0.03	0.34	/		V	" "
.49	+/- 0.03	.49	/		V	" "
.97	+/- 0.03	.97	/		T	JKM-06
2.81	+/- 0.03	2.81	/		T	" "
4.64	+/- 0.03	4.64	/		T	
5.12	+/- 0.03	5.12	/		T	
5.61	+/- 0.03	5.61	/		T	
.38	+/- 0.03	.38	/		T	
1.92	+/- 0.03	1.92	/		T	
5.02	+/- 0.03	5.02	/		T	
9.77	+/- 0.03	9.77	/		T	
11.92	+/- 0.03	11.92	/		T	
14.45	+/- 0.03	14.45	/		T	
19.27	+/- 0.03	19.27	/		T	
21.92	+/- 0.03	21.92	/		T	
23.61	+/- 0.03	23.61	/		T	
27.95	+/- 0.03	27.95	/		T	
28.33	+/- 0.03	28.33	/		T	
16.54	+/- 0.03	16.54	/		T	
7.29	+/- 0.03	7.29	/		T	

Measured by: <i>DC/mn</i>	Audited by: <i>SS</i>	Preliminary Approval:
Date: 14/08/19	Date: 14/08/20	Date:

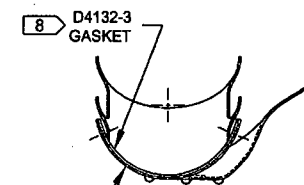
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

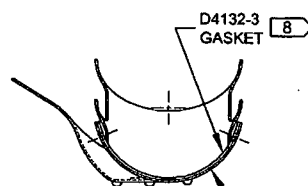
QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D4132-041	WEARPLATE, LH FWD
	X	D4132-042	WEARPLATE, RH FWD
1		D4132-1	WEARPLATE
1	1	D4132-2	WEARPLATE
1	1	D4132-3	GASKET
A/R	A/R	1300 / 1300L	3M SCOTCH-GRIP ADHESIVE



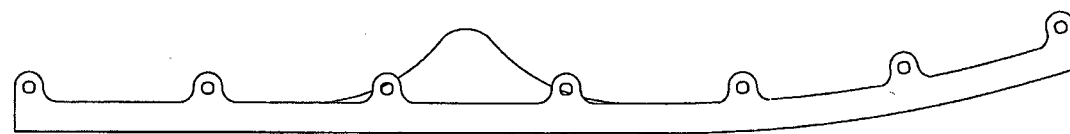
D4132-041 WEARPLATE, LH FWD



D4132-1 WEARPLATE



D4132-2 WEARPLATE



D4132-042 WEARPLATE, RH FWD

RELEASED
2010-10-23

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 113214 MP
14-02-14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N "D4132-xxx" PER QSI 044 6.1 ON INSIDE SURFACE
- 7) WEIGHT: -041/-042 = 2.1 lbs
- 8) BOND D4132-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

B	0.450 WAS 0.300 (B6-5), 0.49 WAS 0.34 (B6-6), 9.774 WAS 9.824 (D4-5, D4-6), 14.448 WAS 14.548 (D5-5, D6-6) 5.024 WAS 5.099 (D4-5, D4-6)	CP	10.09.15
A	NEW ISSUE	CP	10.06.15
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.15		

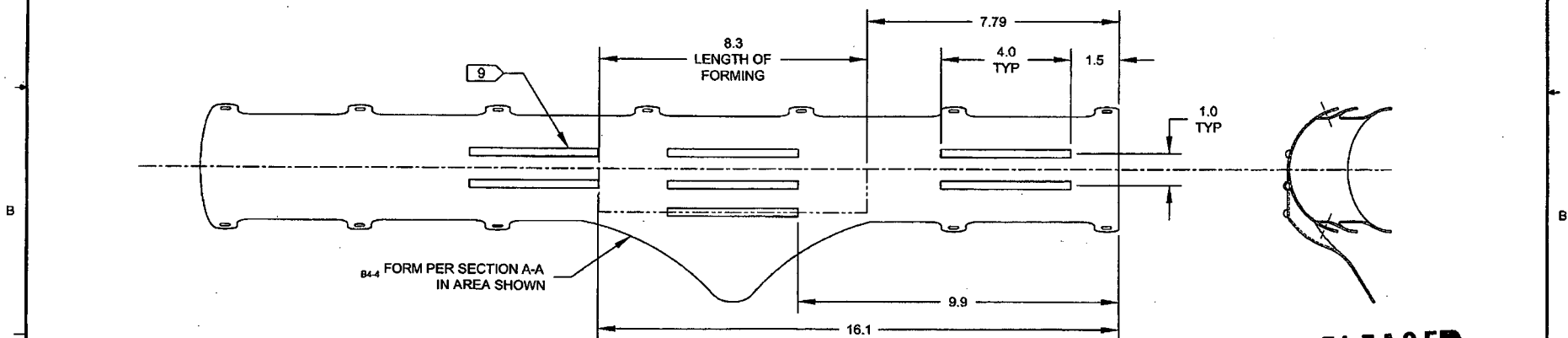
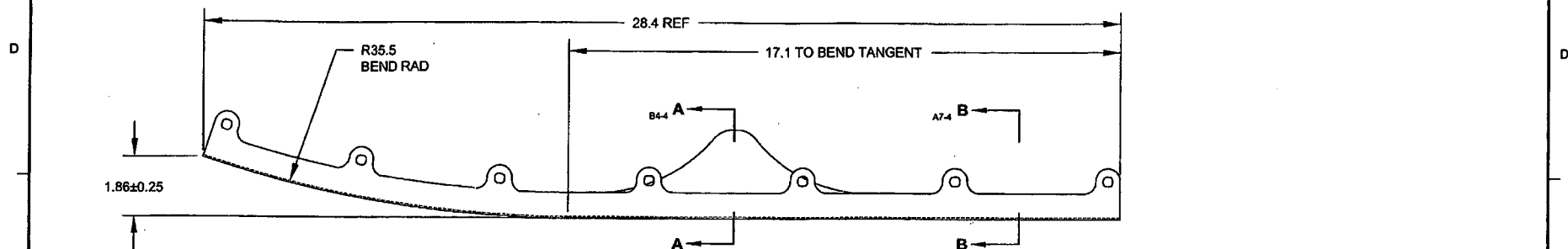
DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D4132 REV. B
SHEET 1 OF 6

TITLE WEARPLATE, FWD SCALE NTS

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8 7 6 5 4 3 2 1



D4132-1 WEARPLATE, LH

RELEASED
2010-10-27
ND

NOTES:

- 1) MATERIAL: MAKE FROM D4132-1F
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) WELD PER QSI 004
- 9) 2059B HARDCOAT WELDS, 0.063 TO 0.125 HIGH

DESIGN	93	DART AEROSPACE USA, INC	
DRAWN	93	PORT HADLOCK, WA	
CHECKED	93	DRAWING NO.	REV. B
MFG. APPR.	93	D4132	SHEET 2 OF 6
APPROVED	93	TITLE	SCALE
DE APPR.	93	WEARPLATE, FWD	NTS
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
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8 7 6 5 4 3 2 1

